

Date: Thursday, 6/21/2007 2:29:16 PM  
 User: Kim Johnston

## Process Sheet

|                       |   |                |                |
|-----------------------|---|----------------|----------------|
| Customer              | CU-DAR001 Dart Helicopters Services   | Drawing Name   | WEARPAD        |
| Job Number            | 33059   | Part Number    | D26483         |
| Estimate Number       | 10313   | Drawing Number | D2648 REV D    |
| P.O. Number           | N/A   | Project Number | N/A            |
| This Issue            | 6/21/2007   | S.O. No.       | N/A            |
| Prsht Rev.            | NC  | Type           | SMALL /MED FAB |
| First Issue           | N/A   | Material       | N/A            |
| Previous Run          | 32465   | Due Date       | 7/10/2007      |
| Written By            | Qty: 200 Um: Each   |                |                |
| Checked & Approved By | Signature: 07/06/22   |                |                |
| Comment               | Est: E 02.09.18 Re-format; Incorporated D2648-1 KJ/RF<br>Est Rev:F Now on Waterjet 06-08-14 JLM |                |                |

## Additional Product

Job Number:



| Seq. #:  | Machine Or Operation: | Description :                              |
|--|-----------------------|--|
| 1.0  | M1010S16GA            | 1010/1025/A21/6aA SHEET<br>                |
| Comment: Qty.: 0.0788 sf(s)/Unit Total : 15.7500 sf(s)<br>1010/1025/A21/6aA SHEET<br>(M1010S16GA)<br>Batch: M 184948 HB 07-07-18 |                       |  |
| 2.0  | WATER JET             | FLOW WATER JET<br>                         |
| Comment: FLOW WATER JET<br>1-Cut as per Dwg D2648<br>*****CUT WITH FILE D2648-1*****<br>Dwg Rev: D<br>Prog Rev: D HB 07-07-18    |                       |  |
| 3.0  | QC2                   | INSPECT PARTS AS THEY COME OFF MACHINE<br> |
| Comment: INSPECT PARTS AS THEY COME OFF MACHINE<br>HB 07-07-18   |                       |  |
| 4.0  | QC8                   | SECOND CHECK<br>                           |
| Comment: SECOND CHECK<br>DSP 019<br>En 07/07/09  |                       |  |
| 5.0  | SMALL FAB 1           | SMALL & MEDIUM FAB RESOURCE 1<br>          |
| Comment: SMALL & MEDIUM FAB RESOURCE 1<br>Deburr if necessary<br>opm<br>07/07/25 (207)   |                       |  |

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 09/09/19  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 33059

Part Number: D26483

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

1-Form as per Dwg D2648 on CNC brake using Jigs DT 8261 and DT 8326.

2-Identify as D2648-3

FF 07-07-31 207

7.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Qty Description Batch  
A/R560Hardcoat M105465

1-Weld as per Dwg D2648 using Jig DT 8210

2-Remove any weld that penetrated through Wearpadif necessary

FC 07/09/15/ 207

8.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

10/07/09/17 207

9.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

10/07/09/17 207

10.0 POWDER COATING POWDER COATING



M105642

207X

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M.b 07/09/18

11.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FC

07/09/18 207

12.0 PACKAGING 1 PACKAGING RESOURCE #1



207X

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

F-P 16

M.b 07/09/18

13.0 QC21 FINAL INSPECTION/W/O RELEASE



207

Comment: FINAL INSPECTION/W/O RELEASE

10/07/09/15

Job Completion



10/07/09/19

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

|                       |              |             |
|-----------------------|--------------|-------------|
| DART AEROSPACE LTD    | Work Order:  | 33059       |
| Description: Wearpad  | Part Number: | D2648-3     |
| Inspection Dwg: D2648 | Rev: D       | Page 1 of 1 |

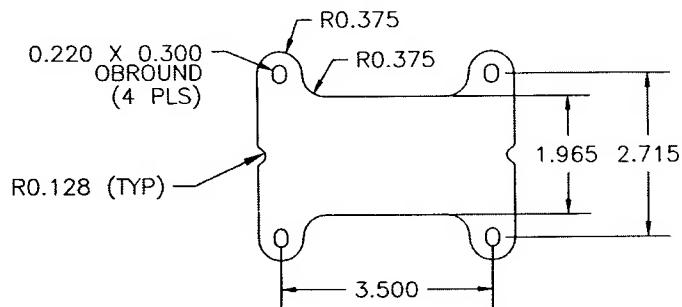
## **FIRST ARTICLE INSPECTION CHECKLIST**

## X First Article      Prototype

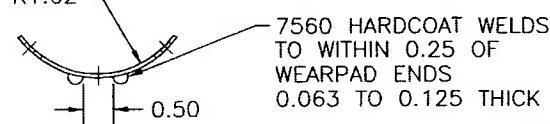
|              |          |             |  |                     |     |
|--------------|----------|-------------|--|---------------------|-----|
| Measured by: | HR       | Audited by: |  | Prototype Approval: | N/A |
| Date:        | 07-07-18 | Date:       |  | Date:               | N/A |

| Rev | Date     | Change    | Revised by                | Approved           |
|-----|----------|-----------|---------------------------|--------------------|
| A   | 06.10.16 | New Issue | KJ/JLM <i>[Signature]</i> | <i>[Signature]</i> |

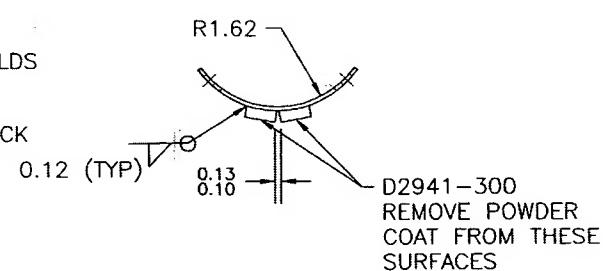
D2648-1 FLAT PATTERN



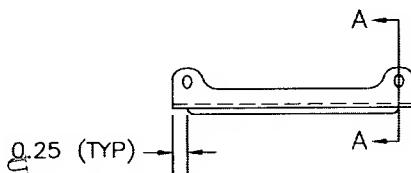
SECTION A-A



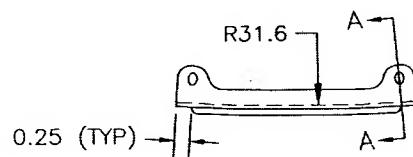
SECTION B-B



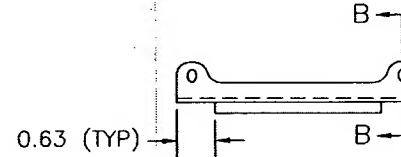
D2648-3 LONGITUDINAL BEND  
(MADE FROM D2648-1)



D2648-5 LONGITUDINAL BEND  
(MADE FROM D2648-1)



D2648-7 LONGITUDINAL BEND  
(MADE FROM D2648-1)



NO. 3059  
WORK ORDER  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
ENGINEERING  
CONTROLLED COPY  
RETURN TO  
SHOP COPY  
BREAK ALL SHARP CORNERS 0.063 MAX  
MATERIAL: 16 GAUGE AISI 1010-1025 OR ASTM A36/A366 STEEL (0.063 THICK)  
FINISH: POWDER COAT GREY (REF. 4.3.5.5) PER DART QSI 005  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
ALL DIMENSIONS ARE IN INCHES

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28

RELEASED  
12.20 DS

12.20 DS  
COPYS  
GIVEN

|                  |                |  |
|------------------|----------------|--|
| D                | 99.11.17       | ADDED D2648-7                              |
| C                | 97.06.26       | R31.6 WAS R19.6                            |
| B                | 97.05.30       | ENLARGE OBRUND, 0.375 WAS 0.250            |
| A                | 97.03.25       | NEW ISSUE                                  |
| DESIGN<br>#      | DRAWN BY<br>RF | DART AEROSPACE USA, INC.<br>BELLEVUE, WA   |
| CHECKED<br>#     | APPROVED<br>#  | DRAWING NO.<br>D2648                       |
| DATE<br>99.11.17 | SCALE<br>1:2   | REV. D<br>SHEET 1 OF 1<br>TITLE<br>WEARPAD |